



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3488-042
Job Sheet 179051



Part No: D3488-042

Job Qty: 25 ea

DAS
21
9-88

Part Name: Blade Fitting RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/13/18

Job Tracking No:

Due Date: 7/2/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG DSK 101 REV D, D3488 REV B IPP Rev:A New Issue 06-02-28 JLM IPP Rev:B As per Rev B 06-03-30
JLM IPP Rev:C Now On Doosan Lathe JLM Verified BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	25 Ea	7/2/18	7/2/18	0.00	0.00	Start Up Machining-2		Incl
100	Doosan	25 pcs	7/2/18	7/2/18	0.00	21.97	Doosan		Incl
110	QC	25 pcs	7/2/18	7/2/18	0.00	0.00	QC2 Machining-2		Incl
120	CNC Vertical Machining	25 pcs	7/2/18	7/2/18	0.11	17.14	HAAS1-3		DAS 52 18/07/26
130	QC	25 pcs	7/2/18	7/2/18	0.00	0.00	QC2 Machining-2		DAS 52 18/07/26
140	QC	25 pcs	7/2/18	7/2/18	0.00	0.00	QC8 Machining-2		DAS 52 18/07/26
150	HandFinish	25 pcs	7/2/18	7/2/18	0.00	0.74	HandFinish1		SA 18-07-30
160	Powdercoat	25 pcs	7/2/18	7/2/18	0.00	0.88	Powdercoat1		SL 18-7-31
170	QC	25 pcs	7/2/18	7/2/18	0.00	0.00	QC3		SL 18-7-31
180	HandFinish	25 pcs	7/2/18	7/2/18	0.00	0.00	HandFinish4		BEB 18-07-31
190	QC	25 pcs	7/2/18	7/2/18	0.00	0.00	QC5		SL 18-7-31
200	Packaging	25 pcs	7/2/18	7/2/18	0.00	0.00	Packaging3-1	FP001	BEB 18-07-31
210	QC21-SA	25 Ea	7/2/18	7/2/18	0.00	0.00	QC21		DAS 21 9-88

Part Op 100 - 1-Turn as per Dwg DSK 101 & Folio FA625

Descriptions: 120 - 1-Machine as per Folio FA627 & Dwg D3488

160 - START TIME: 9:15AM 320F 9:45AM

180 - Install Inserts as per Dwg D3488

200 - LOCATION : FP001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6103-003	Round Billet, Aluminum	25 Ea (1 ea)	90-Start up Operation	
ALS7-1032-225	Insert	100 Ea (4 ea)	180-HandFinish	5038205

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6103-003	25	44	0
180-HandFinish	ALS7-1032-225	100	1,048	0

Part Specifications

Specifications could not be found.

DART AEROSPACE LTD		Work Order: 179057
Description: Blade Fitting, RH / Turning Detail for D3488-1/-2		Part Number: D3488-2
Inspection Dwg: D3488 / DSK101 Rev: B / D		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Lathe Section						
Ø2.150	+/-0.005	2.151"				
Ø2.780	+/-0.005	2.7805"				
Ø3.125	+/-0.010	3.1253"				
Ø3.346	+/-0.010	3.346"				
0.125 x 45°	+/-0.010 x +/-0.1°	1/8 x 45°				
8.000	+0.030/-0.000	8.006"				
9.250	+/-0.010	9.247"				
0.188	+/-0.010	R.032				
R0.032	+/-0.010	R.032				
R0.062	+/-0.010	R.062				
Ø0.297	+0.005/-0.001	.300"				
Ø0.430	+/-0.010	.432"				
0.100	+/-0.010	.098"				
0.125	+/-0.010	.120"				
2.620	+/-0.010	2.621"				
3.500	+/-0.010	3.499"				
1.005	+/-0.010	1.007"				
Ø0.484	+0.005/-0.001	.486"				
1.180	+/-0.010	1.179"				
3.150	+/-0.010	3.149"				
3.070	+/-0.010	3.063"				
R0.063	+/-0.010	R.063				

DART AEROSPACE LTD		Work Order:	179051
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Inspection Dwg: D3488 / DSK101 Rev: B / D		Page 2 of 2	

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Milling Section						
Ø0.508	+0.006/-0.001	0.510	✓		Gage Pin	
0.750	+/-0.010	0.750	✓		H.G.	
1.500	+/-0.010	1.500	✓		Vern.	
11.18	+/-0.030	11.180	✓		H.G.	
R0.062	+/-0.010	0.062	✓		Rad. Gage	
0.125	+/-0.010	0.125	✓		Vern.	
0.590	+/-0.010	0.5845	✓		H.G.	
0.793	+/-0.010	0.793	✓		H.G.	
1.351	+/-0.010	1.350	✓		H.G.	
1.317	+/-0.010	1.3185	✓		Vern.	
1.802	+/-0.010	1.801	✓		H.G.	

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>	Prototype Approval:	N/A
Date:	Date: 18/07/26	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.03.31	New Issue	KJ/JLM	
B	08.09.19	Reformat P/O D3488-042	KJ/JLM	
C	08.12.02	Dimension 8.000 removed	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>

DQA:

Date: _____

WORK ORDER NOI

QA Closed:

Date: _____

Work Order: _____

Part No. _____

NCR No. _____

Date: _____

Step #: _____

DISPOSITION

Rework _____

Scrap _____

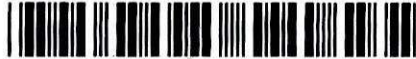
Use-as-is _____

Suspected Unapproved _____

Description Work Order Deviation

Date: 07/18/18

Container No: S093460



Part: D3488-042

Job No: 179051

Serial No/Batch: S093460

Revision: _____

Inspector: _____

Exp Date: _____

Instructions: _____

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Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 832-5200
Email: sales@dartaero.com
www.dartaerospace.com

QC / QA Coordinator
Approval**FAULT CATEGORY****Root Cause**

Environment	No Re-verification
Design	Operator
Doc/Data	Offset/Setup
Equip/Tooling	Supplier
Handling/Pre	Training
Material	Use for Testing
Internal Transport	Poor Information
Tribal Knowledge	Rushing
LOA	Product Improvement
Substation	Process Improvement
Past Expiry Date	Manufacturing Process
Misidentified	Past Due

Pressure/Forced
Bending
Centre Not Concentric
Cracks
Crimp/Kink/Ripple/Wave
Cuffs
Crushing
Heat Treat
Wave/Twist in Tube
Marks/Chatter

Temperature/Cure
Set-up
BOM/Route
Broken/Damage/Defect
Inspection Incomplete/Unqualified
Contamination
Countersink
Cut Too Short
Instructions Incomplete/Unclear
Drill Holes

Power Loss/Surge
Folio/Program
Grain
Weld
Wrong Stock Pulled
Out of Sequence
Off-set
Mislabeled
Fit/Function
Misaligned/off center

Positioned Wrong
Outside Dimensions
Over/Under tolerance
Part Incorrect
Part Lost/Missing
Part Moved
Drawing
Finish
Misread
Turning Sequence

OTHER: _____